

Date:  
User:Monday, 9/11/2006 3:45:22 PM  
Kim Johnston

## Process Sheet

Split  
8B 06/12/04

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GAS SPRING  
 Job Number : 28488-2  
 Estimate Number : 10336  
 P.O. Number : N/A Part Number : D2807  
 This Issue : 9/11/2006 S.O. No. : N/A Drawing Number : D2807 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : C  
 Previous Run : 27562 Material : N/A  
 Due Date : 9/30/2006 Qty: 40 Um: Each  
 Written By :  
 Checked & Approved By : 06 09.12  
 Comment : Est: D 05.06.21 Removed painting; Changed supplier  
 KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 2009

C 2006107/12 (40)

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

2.0 SXF6S6050080S6L115N GAS SPRING

Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)  
SUPPORT PROP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

LB 06/10/10 (40)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Job 10:23 40

5.0 D28073 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

2 D2807-3 Lug Batch: B 28488 35

8B 06/12/04  
(40)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: HP Date: 06/12/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:45:22 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 28488

Part Number: D2807

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig.

2-Remove lettering and logo with wash and wipe.

SB 06/12/04

35

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/05 35

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57387

06/12/05 35

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/05 35

Job Completion



06/12/05



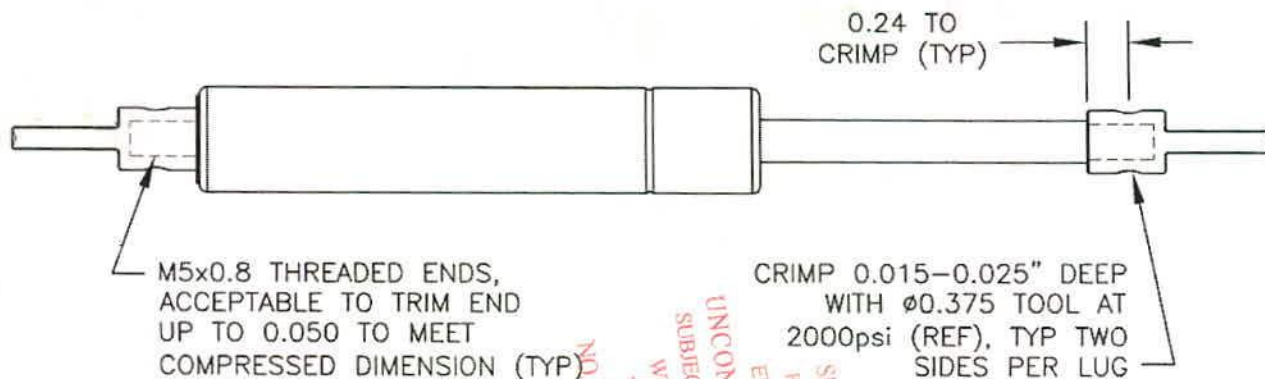
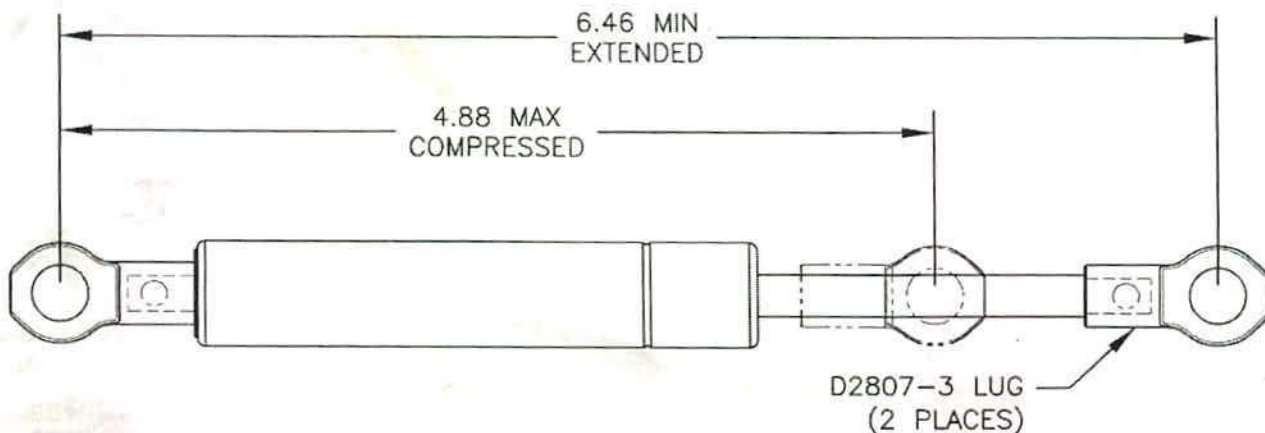
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****RELEASED**  
#05-06-16**D2807 GAS SPRING**

- 1) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS

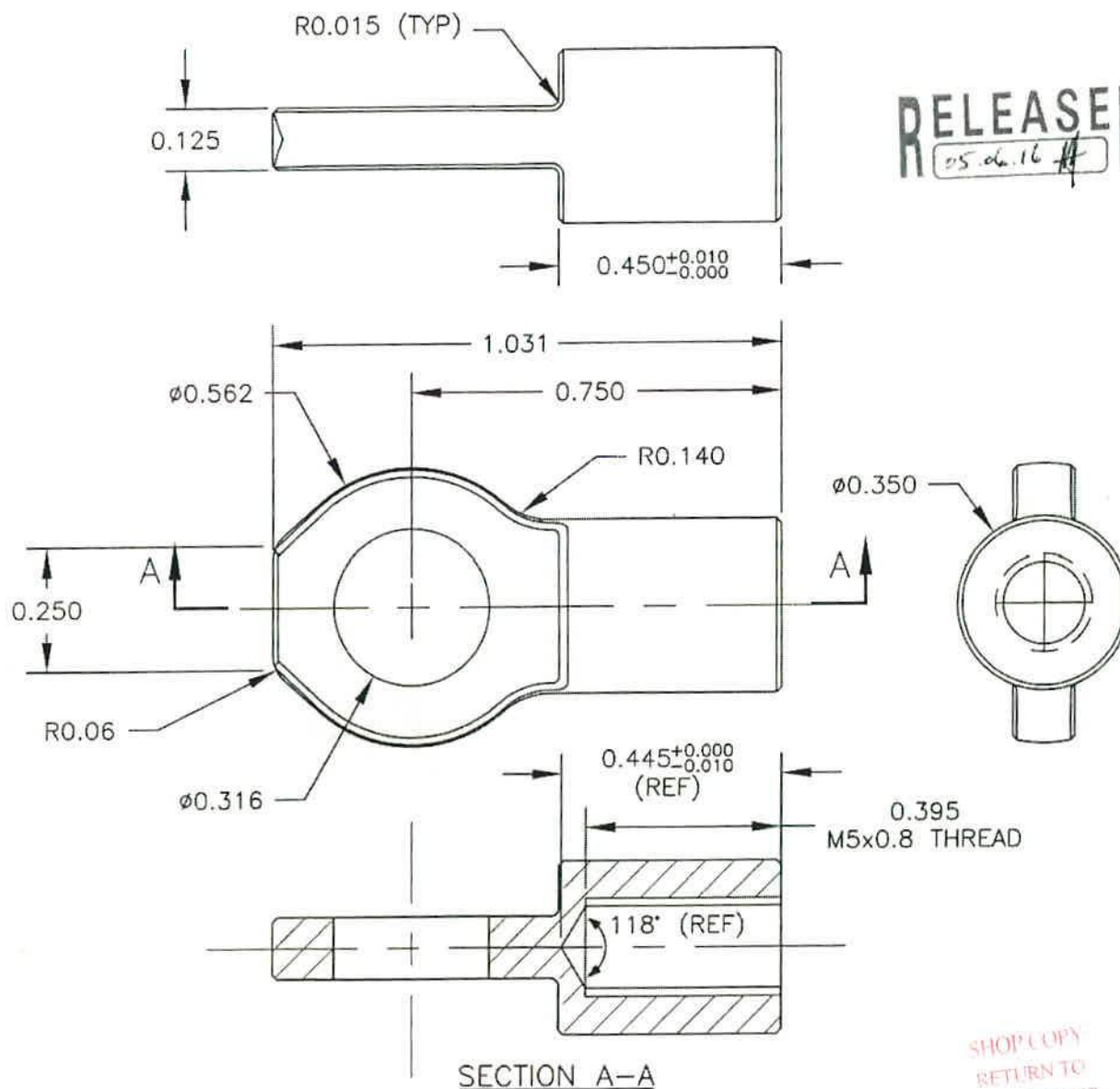
POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.25	TITLE	D2807	REV. C
		GAS SPRING		SHEET 1 OF 2
				SCALE
				1:1
A	00.11.03	NEW ISSUE		
B	05.03.16	ADD FINISH		
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG		

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 28488

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**ArvinMeritor**

58776/001

SERIAL No.	DUR REF.
	58776
DATE	
051006	
A/C No.	AREA
2011	46
CUSTOMER REF. No.	
F000002009	

VAT. REGISTRATION No. GB/738 8577 7

DELIVERY TO:

DART AEROSPACE LTD

SHIP FEDEX ECONOMY SERV  
ACC NO 151793240

V.A.T. REGISTRATION No. GS 738 8577 71

QTY. ORDERED	PART NUMBER	DESCRIPTION	DUE DATE	W ORDER NUMBER <del>QTY. NO.</del> XXXXXXXXXX	BATCH No.
40	EA	SXF6050500047 SXF6 S6 050 0 80 S6 L 20mm 32AWS 115N NNN SPI	04OCT06	171143	40

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E-mail: [info.amc@arvinmeritor.com](mailto:info.amc@arvinmeritor.com)  
Website: [www.camloc.com](http://www.camloc.com)

FED EX

26-OCT-2006 13:38 FROM ARVIN MOTION CONTROL

TO 900016136321053

P.01